Work Order ID 104529

July-12-13 10:05:19 AM

104529

Item ID: D3782-041

Revision ID:

Item Name: Front Inboard Leg Assembly

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 7/12/13 **Start Qty:** 2.00 *2*

Required Date: 7/12/13 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-07-16 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3782	**Revision Nbr** Rev B								
100 *100* Packaging Packaging	Pick Kit **Memo**	0.00 0.00				2	Ø		FF 13-08-28
110 *110* Small Fab Small Fab	Small Fab **Memo** 1-assemble as per dwg D3782 ****install AN45-13A eye bolt as shown for D412-769-041**** ****install AN45-13A eye bolt in reverse for D412-769-042****	0.00 0.00				2	Ø		FF 13-08-28
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	DAS 27 9-89 13.8.28			2			

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: ________

Part No. ________

NCR No. ________

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other ________

Work Order ID 104529
July-12-13 10:05:19 AM

104529

Item ID: D3782-041
Revision ID:
Item Name: Front Inboard Leg Assembly

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 7/12/13 **Start Qty:** 2.00 *2*
Required Date: 7/12/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____
QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: ST249 Memo	0.00 0.00				2X		M.W.	13-08-28
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						13/9/30	

13-08-29

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Suspected Unapproved ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ________

Picklist Print

July-12-13 10:05:19 AM

Work Order ID: 104529

Parent Item: D3782-041

Parent Item Name: Front Inboard Leg Assembly

Start Date: 7/12/13 **Required Date:** 7/12/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C 10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3768-1 Front Inboard Leg		Manufactured	No			110	Each	6.0000	1	2	FF	13-08-28	
				Location		**Loc Qty**	**Loc Code**						
				st493		6							
				87472		6				2			
D3787-1 Foot		Manufactured	No			110	Each	28.0000	1	2	FF	13-08-28	
				Location		**Loc Qty**	**Loc Code**						
				ST249A		28							
				87455		18				2			
				97170		10							
D3762-041 Front Leg Fitting Assembly		Manufactured	No			110	Each	7.0000	1	2	FF	13-08-28	
				Location		**Loc Qty**	**Loc Code**						
				ST250		7							
				85913		4							
				97206		3				2			
AN45-13A EYE BOLT		Purchased	No			110	Each	20.0000	1	2	FF	13-08-28	
				Location		**Loc Qty**	**Loc Code**						
				ST361		20							
				122204		1							
				122843		19				2			

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: ________

Part No. ________

NCR No. ________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ________

Work Order ID: 104529

Parent Item: D3782-041

Parent Item Name: Front Inboard Leg Assembly

Start Date: 7/12/13 **Required Date:** 7/12/13

Start Qty: 2.00 **Required Qty:** 2.00

Item	Alt	Type				UOM	Cost	Seq	Qty	Sign
AN5-13A BOLT		Purchased	No		110	Each	112.0000	1	2	FF 13-08-28
			Location		Loc Qty	Loc Code				
			GA		12					
				116003	12					
			ST362		100					
				124805	40			2		
				124969	60					
MS21042L5 Nut		Purchased	No		110	Each	1,605.0000	2	4	FF 13-08-28
			Location		Loc Qty	Loc Code				
			ST314		624					
				125654	624			2		
			ST506		1					
				123900	1					
			st507		980					
				125535	980					
AN960JD516 Washer	NAS1149D0563J	Purchased	No		110	Each	2.0000	3	6	FF 13-08-28
			Location		Loc Qty	Loc Code				
			ST504	125807	2			2		
				1069059	2					

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

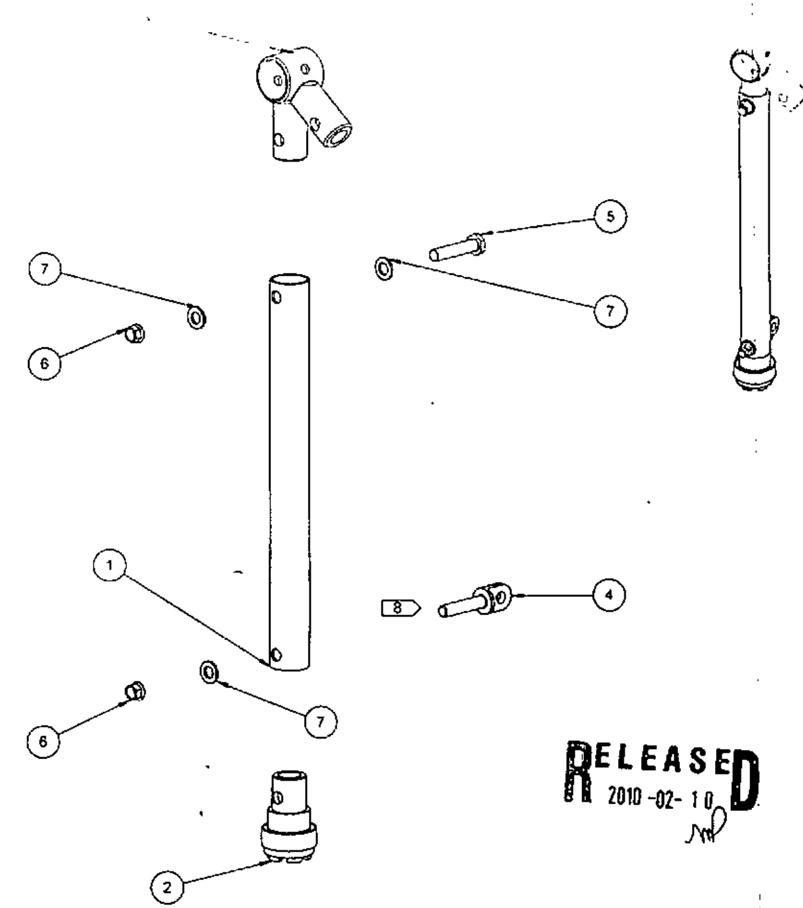
Work Order: ________ Part No. ________ NCR No. ________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	________	
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	________	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	________	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

ITEM NO		PART NUMBER	DESCRIPTION
1		D3768-1	FRONT INBOARD LEG
2		D3787-1	FOOT
3		D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs
8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

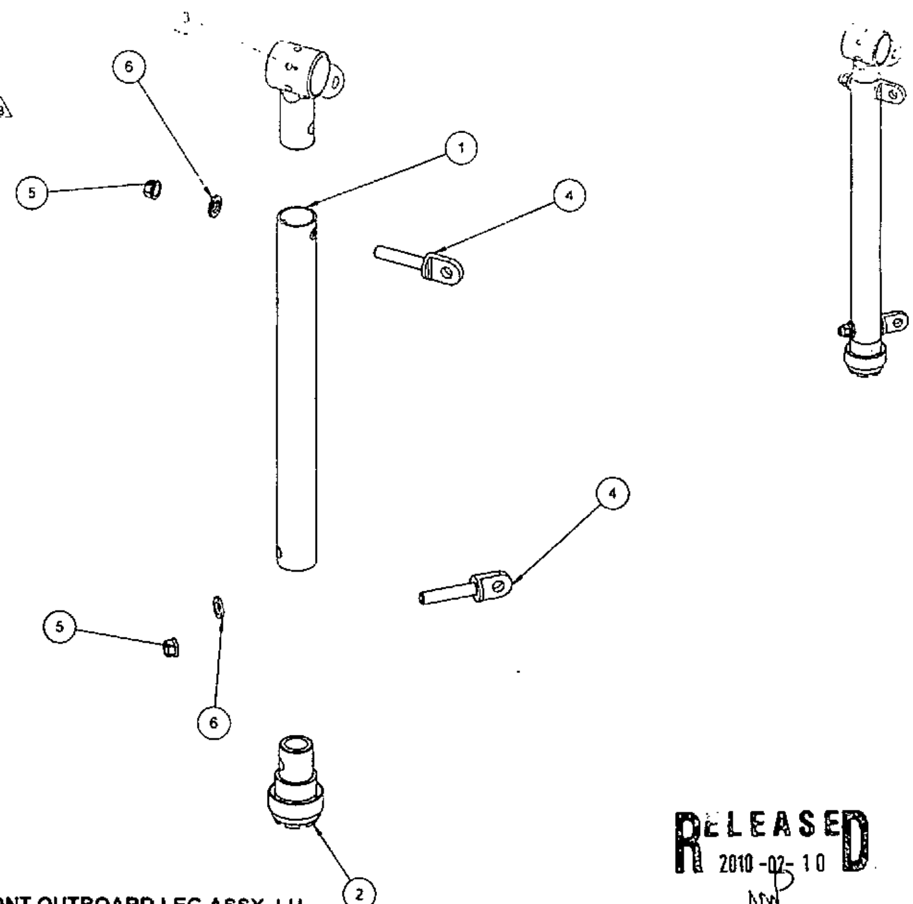
REV.	DESCRIPTION	BY	DATE
B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7		10.01.21
A	NEW ISSUE	HS	08.06.04

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3782 — REV. B — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE LEG ASSEMBLY — SCALE NTS
DE APPR.		
DATE	10.01.21	

104529

ITEM NO		PART NUMBER	DESCRIPTION
1		D3798-3	[illegible]T OUTBOARD LEG LH
2		D3787-1	[illegible]OOT
3	1	D3752-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)

B



D3782-043 FRONT OUTBOARD LEG ASSY, LH

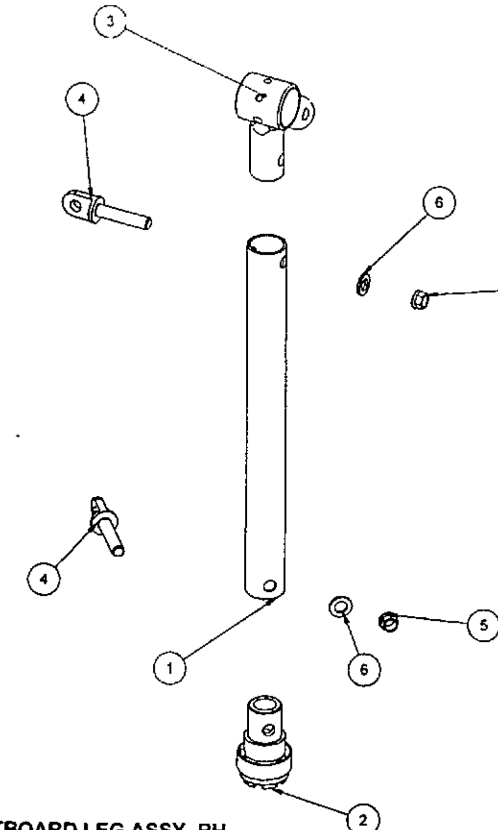
RELEASED 2010-02-10

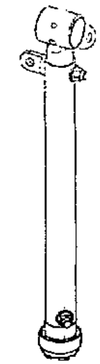
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3782 — REV. B — SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE LEG ASSEMBLY — SCALE NTS
DE APPR.		
DATE	10.01.21	

104529

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3752-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)





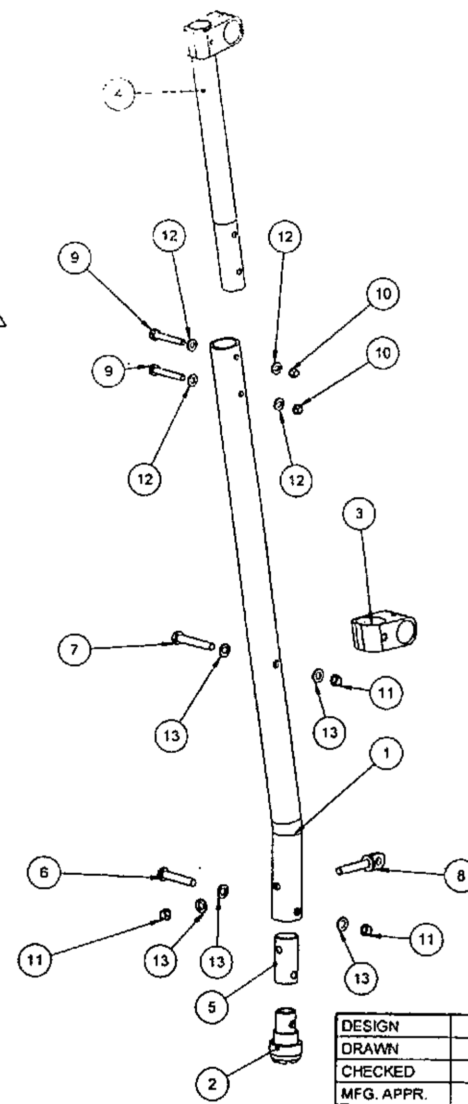
D3782-044 FRONT OUTBOARD LEG ASSY, RH

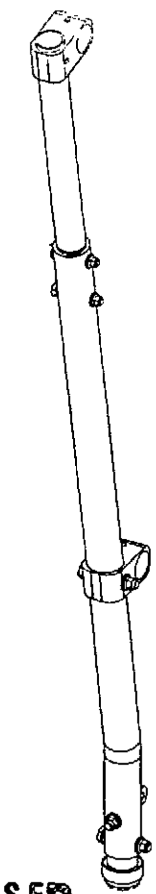
RELEASED 2010-02-10

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3782 — REV. B — SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE: LEG ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	10.01.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD

ITEM NO.	045	PART NUMBER	DESCRIPTION
1		D3772-1	BACK LEG
2		D3787-1	FOOT
3		D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)





D3782-045 BACK LEG ASSY

RELEASED 2010-02-10

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.71 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3782 — REV. B — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: LEG ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD

104529